

Date: Thursday, 12/07/2007 10:34:28 AM  
 User: Linda Lacelle

## Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	WEARSHOE
Job Number	32738		Part Number	D35645
Estimate Number	12786		Drawing Number	D3564 UNDER REVIEW
P.O. Number	N/A		Project Number	N/A
This Issue	12/07/2007	S.O. No. N/A	Drawing Revision	F C
Prsht Rev.	NC		Material	N/A
First Issue	01/06/2007	Type SMALL /MED FAB	Due Date	08/06/2007
Previous Run	31420		Qty:	20
Written By			Um:	Each
Checked & Approved By				
Comment	Est Rev:A	New Issue 07-03-08 ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M304S16GA	304/316 .063 Sheet
		 <b>Comment:</b> Qty.: 1.1099 sf(s)/Unit Total: 22.1970 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: M104725 <b>B 07-07-13</b>
2.0	WATER JET	FLOW WATER JET
		 <b>Comment:</b> FLOW WATER JET 1-Cut as per Dwg D3564 Dwg Rev: C Prog Rev: C  <b>2-Deburr if necessary</b> <b>B 07-07-16</b>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 <b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <b>B 07-07-16</b> <b>20</b>
4.0	QC8	SECOND CHECK
		 <b>Comment:</b> SECOND CHECK <b>Er 07/07/16 X20</b>
5.0	BRAKE NC	NC BRAKE
		 <b>Comment:</b> NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT 3155 and DT 3179 <b>Qm 07/07/17 20</b> Form Joggle as per Dwg D3564 on brake using Jig DT 8157 <b>8B 07/07/17 20</b>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/07/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/07/2007 10:34:28 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 32738

Part Number: D35645

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

en 07/07/17

contd

120

20X

7.0 POWDER COATING

POWDER COATING



M104846.

m-l 07/07/20

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



m-l 07/07/21

20J

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



20X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: F-P-14

m-l 07/07/23

10.0 QC21

FINAL INSPECTION/W/O RELEASE



00  
D 07/07/23

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



1 07/07/23

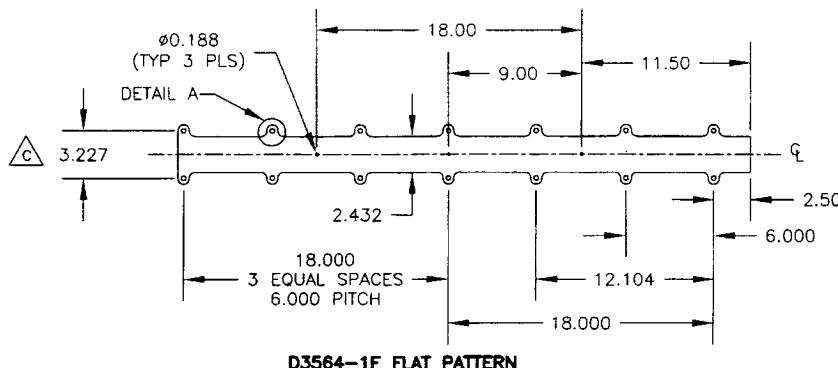
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



R50.0

30.50 FOR D3564-1  
27.56 FOR D3564-3  
(DISTANCE TO START OF JOGGLE)

8.50 ON FLAT

C

DETAIL B

**D3564-1/-3 BENDING DETAIL**  
(MAKE FROM D3564-1F)

8.50 ON FLAT

C

FOR -9 ONLY  
DETAIL B

**D3564-9/-11 BENDING DETAIL**  
(MAKE FROM D3564-1F)

2059B HARDCOAT WELD  
4.0 LONG  
0.063 TO 0.125 HIGH  
(TYP. 11 PLS.)  
WELD AFTER BENDING AS  
ILLUSTRATED PER DT8308



**D3564-1/-3/-9/-11 WELDING DETAIL**

W/U 33214

**RELEASED**

07-06-28

**D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL  
AND IS SUPPLIED ON THE EXPRESS CONDITION  
THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

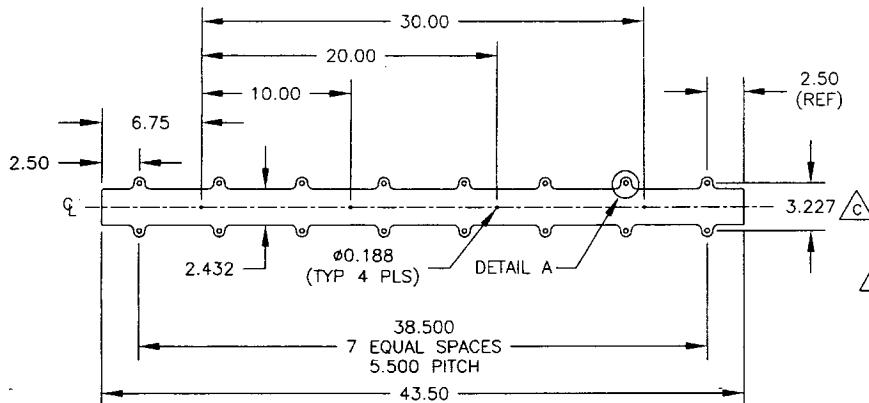
C	07.04.17	MOVE TAB OUTBOARD, DETAIL A
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.12.18	NEW ISSUE
DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	<b>DART</b> DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED <i>RF</i>	APPROVED <i>RF</i>	DRAWING NO. D3564
DATE 07.04.17	TITLE WEARSHOE	REV. C SHEET 1 OF 2 1.8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

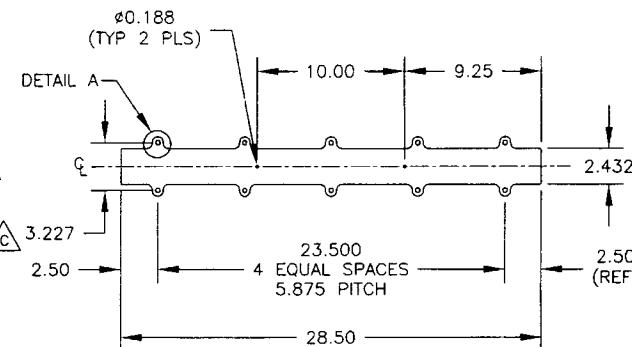
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

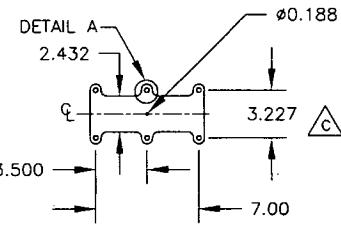
NOTE: Date & initial all entries



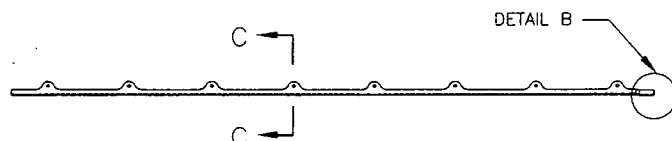
**D3564-5F FLAT PATTERN**



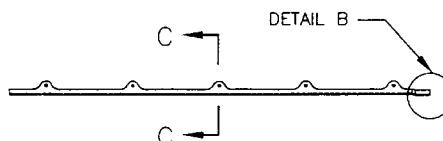
**D3564-7F FLAT PATTERN**



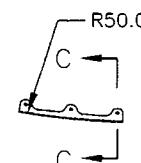
**D3564-13F FLAT PATTERN**



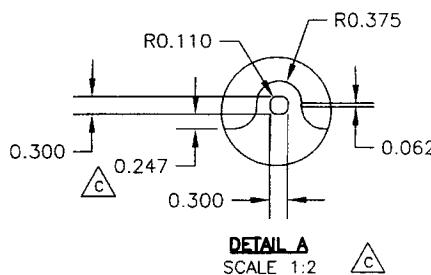
**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)



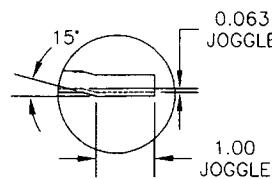
**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)



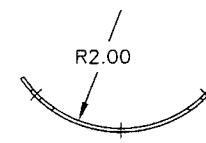
**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)



**DETAIL A**  
SCALE 1:2



**DETAIL B**



**SECTION C-C**

RELEASED  
07.06.2014

**COPYRIGHT © 2006 BY DART AEROSPACE LTD.**  
**THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL**  
**AND IS SUPPLIED ON THE EXPRESS CONDITION**  
**THAT IT IS NOT TO BE USED FOR ANY PURPOSE**  
**OR COPIED OR COMMUNICATED TO ANY OTHER**  
**PERSON WITHOUT WRITTEN PERMISSION FROM**  
**DART AEROSPACE LTD.**

COPYRIGHT © 2006 BY DART AEROSPACE LTD.		DESIGN <del>PH</del>	DRAWN BY <del>PH</del>	<b>DART</b>	DART AEROSPACE LTD. HANDBURY, ONTARIO, CANADA	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED <del>PH</del>	APPROVED <del>PH</del>	DRAWING NO. D3564	REV. C	SHEET 2 OF 2
		DATE 07.04.17		TITLE WEARSHOE	SCALE 1:5	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32738
Description: WEAR SHOE	Part Number:	D 3564-5
Inspection Dwg:	Rev: C	Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

## First Article      Prototype

Measured by: <u>FB</u>	Audited by: <u>EN</u>	Prototype Approval: <u>W/A</u>
Date: <u>07-07-13</u>	Date: <u>07/07/16</u>	Date: <u></u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	